

Work Order ID 69289

Friday, May 06, 2011 11:52:27 AM



Page 1

Item ID:	D2279	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Spacer					
Start Date:	5/6/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	5/9/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-11-11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2279	Rev D								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	I-Cut as per Dwg D 2279 <input type="checkbox"/> Dwg Rev: <u>D</u> <input type="checkbox"/> Prog Rev: <u>D</u> <input type="checkbox"/> 2- Deburr if necessary								
2024.040									
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

1311-5-18

1311-5-18

730 74 P10 →

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2279 PAR #: d/p. Fault Category: Small PAB NCR: Yes No DQA: NA Date: 11.06.07
11-1647 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/06/07

NCR: <u>69289</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>9.35</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/05/09</u>	<u># 100</u>	<u>Found Qty x14 with a notch in side the hubs (known hubs not all) i.e. machine malfunction</u>	<u>11.05.31</u>	<u>→ Scrap + Destroy and Reorder Qty x14 in 113162</u>	<u>11/15/30</u>	<u>11/05/30</u>	<u>11.05.31</u>	<u>11/05/30</u>

NOTE: Date & initial all entries

Work Order ID 69289

Friday, May 06, 2011 11:52:27 AM



Page 2

Item ID: D2279

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 5/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Form As per Dwg D2279	0.00 0.00							
			SB	1103/30		(30)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
						(20)			
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
						130			4/11 6/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69289

Friday, May 06, 2011 11:52:27 AM



Page 3

Item ID: D2279

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 5/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				30	0	11-5-3L	
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>6-A</u> Memo	0.00 0.00						EP 11/06/01 (30)	
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/6/01 MF 11-06-02	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, May 06, 2011 11:52:33 AM

Page 1

Work Order ID: 69289



Parent Item: D2279



Parent Item Name: Step Spacer


Start Date: 5/6/2011

Required Date: 5/9/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev: A New Issue 05-11-07 JLM
IPP Rev: B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040  2024-T3 .040 sheet		Purchased	No			100	sf	54.0000	0.147	3.094737	4, 1315-18		

Location

Loc Qty

Loc Code

MAT022

54

112291

0.5

112331

4.7

113162

48.8

113162

67

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

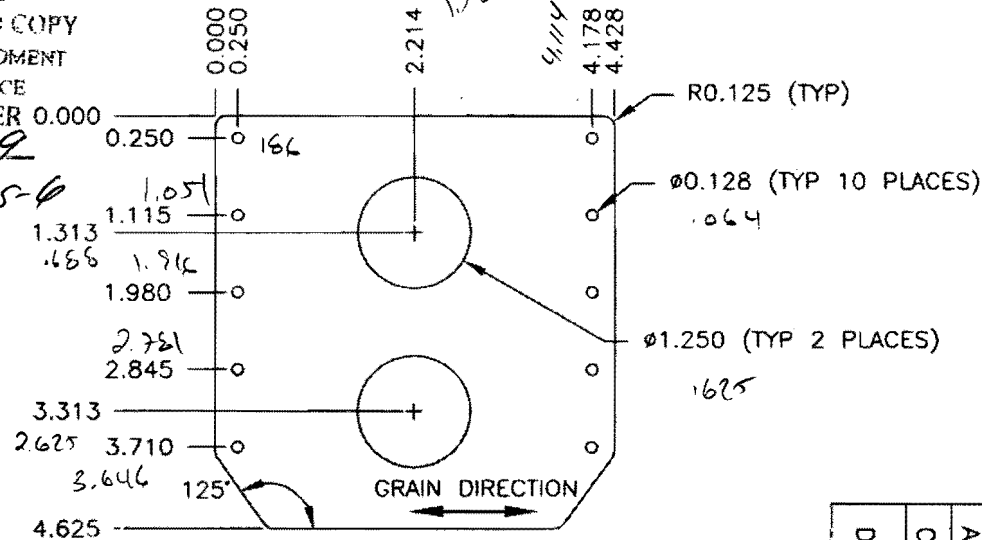
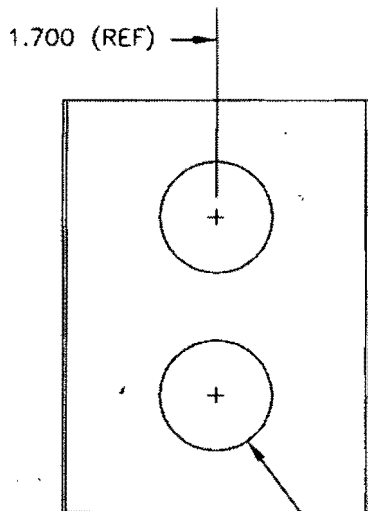
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY

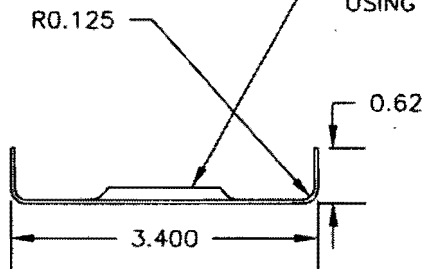
RETURN TO

ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 69289



FLAT LAYOUT

FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)



UNDER REVIEW

RELEASED
98.10.08 DS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
BW	JP		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	JP	D2279	
DATE	TITLE	SCALE	
98.10.05	STEP SPACER	1:2	
A	94.10.13	NEW ISSUE	
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881	
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries